

Date: Friday, 12/2/2005 1:32:54 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SUPPORT BRACKET		
Job Number	: 25073			Part Number	: D23623		
Estimate Number	: 10260			Drawing Number	: D2362 REV E1		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 12/2/2005 S.O. No. : N/A			Drawing Revision	: E1		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: 12/1/2005 Type : MACHINED PARTS			Due Date	: 12/8/2005 Qty: 2 Um: Each		
Previous Run	: N/A						
Written By	: See comment below						
Checked & Approved By	: See comment below						
Comment	: Est: G 00.05.18 Added inspection level 8 EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		 Comment: Take from stock D2362-5 B 13344 X2 Machine per folio D2362-3 BL 05.12.05
2.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: Inspect Level 2 BL 05.12.05 Z
3.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK SD 05.12.05 Z
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr BL 05.12.05 Z
5.0	POWDER COATING	POWDER COATING
		 Comment: POWDER COATING Powder Coat Gloss White (Ref 4.3.5.1)as per Dart QSI 005 4.3 MM 05 12 08 Z
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		 Comment: INSPECT POWDER COAT SB 05/12/08 Z

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 25073

Part Number: D23623

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 D23971 Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rubber Cushion

made by Rand

Pick:

Qty	Part number	Description	Batch
1	D2397-1	Rubber	B16919



SB 05/12/08

8.0 D23973 Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rubber Cushion

made by Rand

Pick:

Qty	Part number	Description	Batch
1	D2397-3	Rubber	B16919

SB 05/12/08

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch H16194

SB 05/12/08

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ins 12-08 2

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 39

16 05/12/08

(2)

12.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

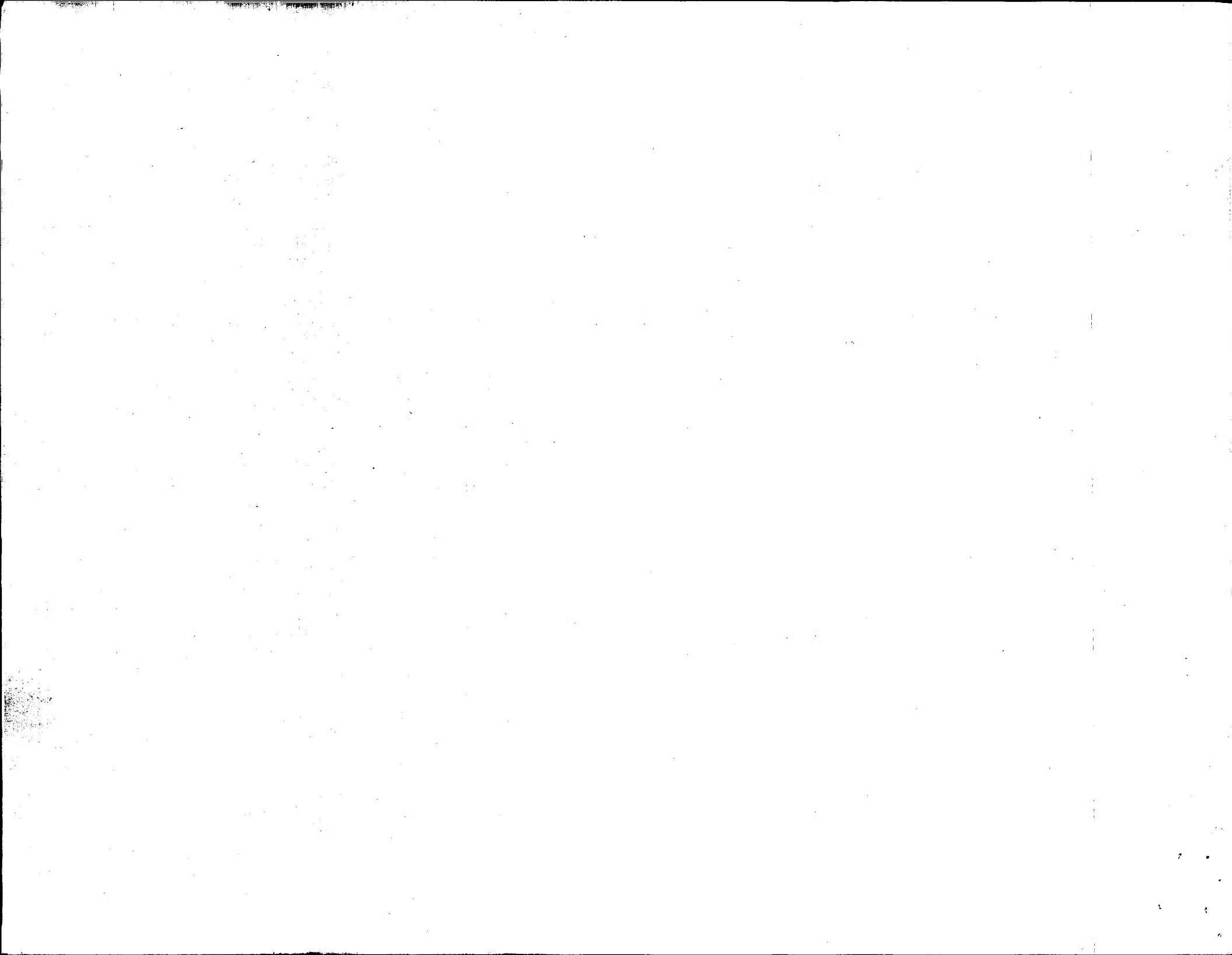
Inspection Level 21

16 05/12/08 (2)

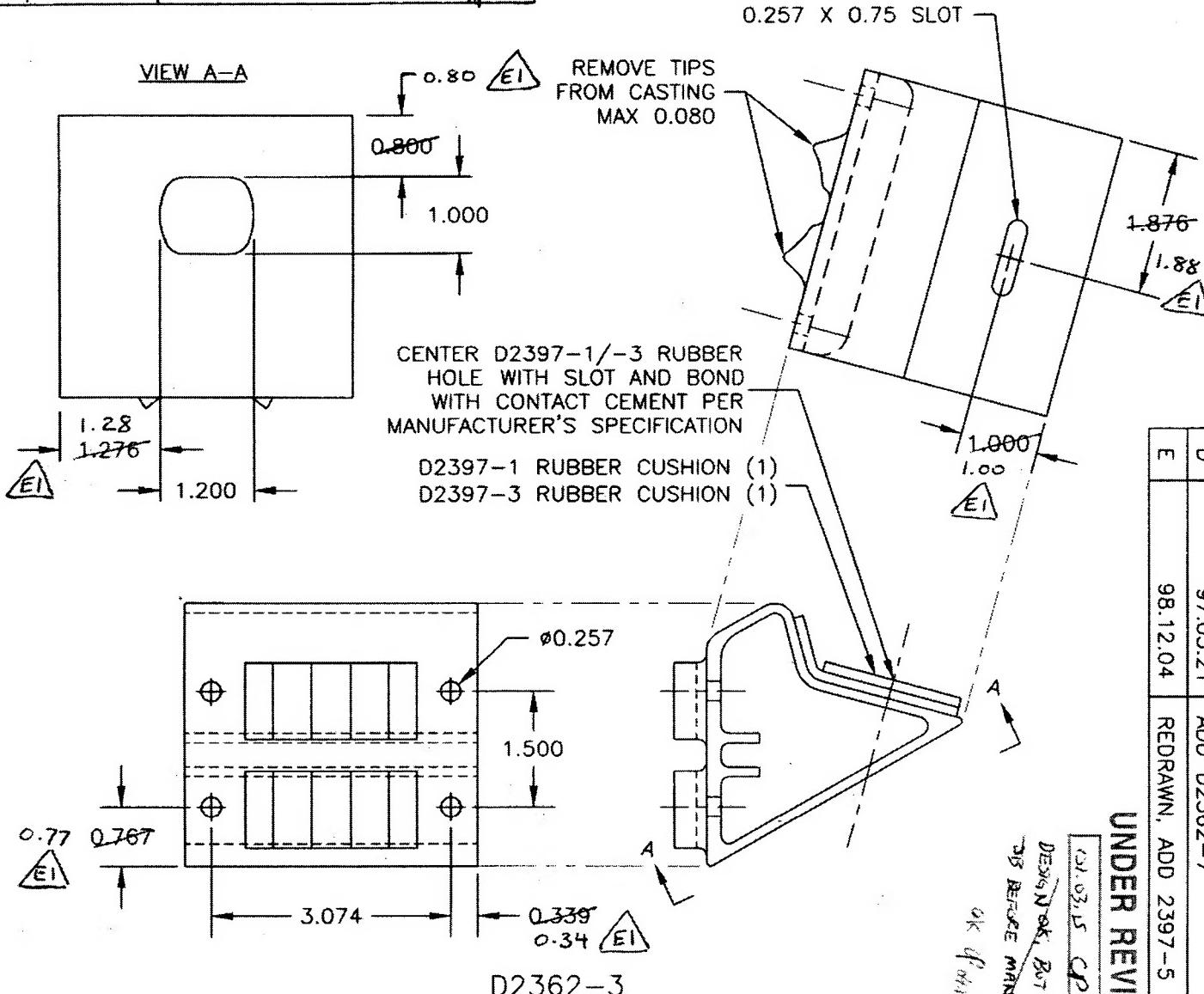
Job Completion



u



EL 03.10.07 TOLERANCE CHANGE ~~RT~~



DESIGN BV	DRAWN BY GP	DART AEROSPACE LTD
CHECKED KE	APPROVED H	HAWKESBURY, ONTARIO, CANADA
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

131.03.15 GP

DESIGN OK BUT CHECK WITH
3B BEFORE MANUFACTURE

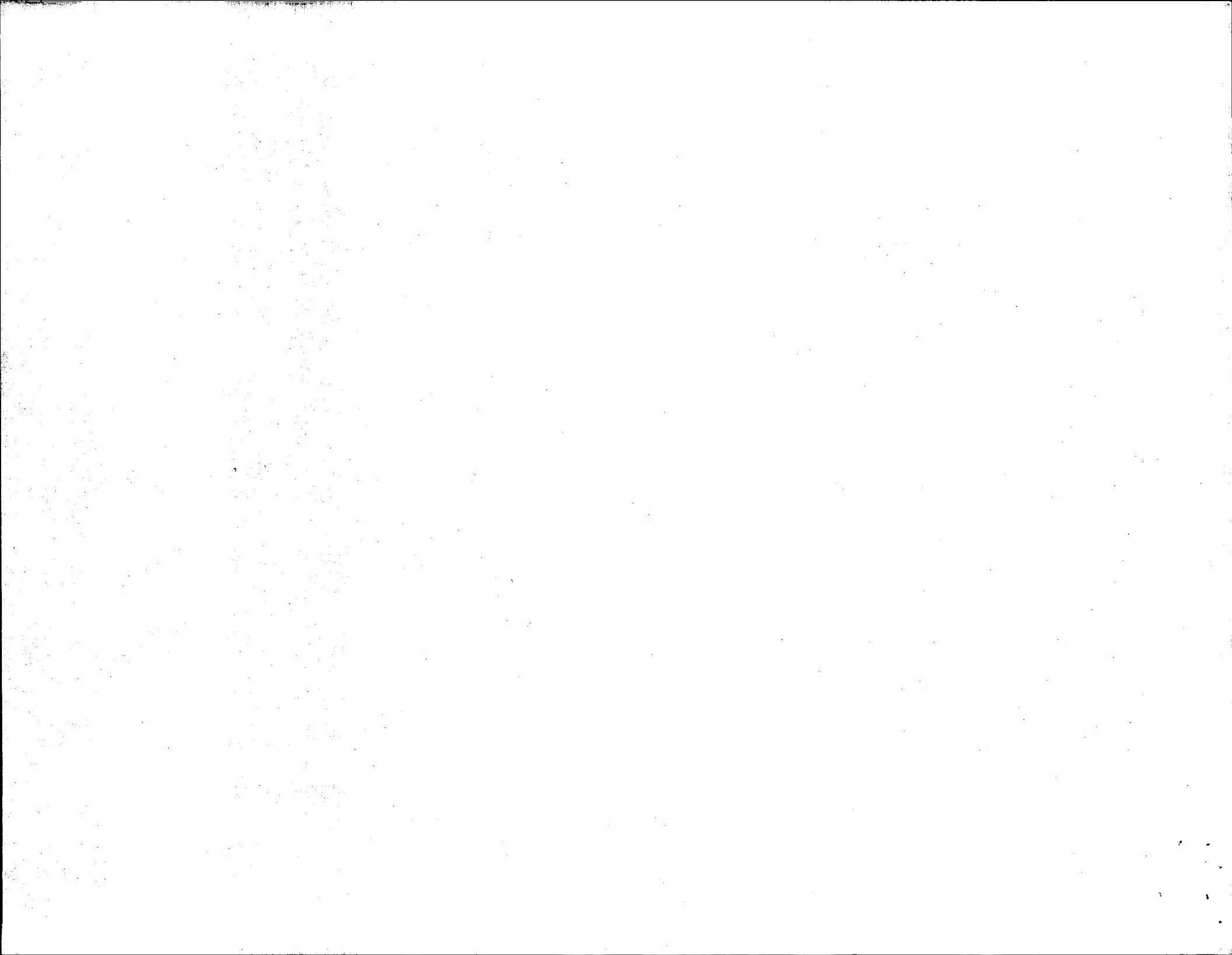
OK
if
OK

NOTES:

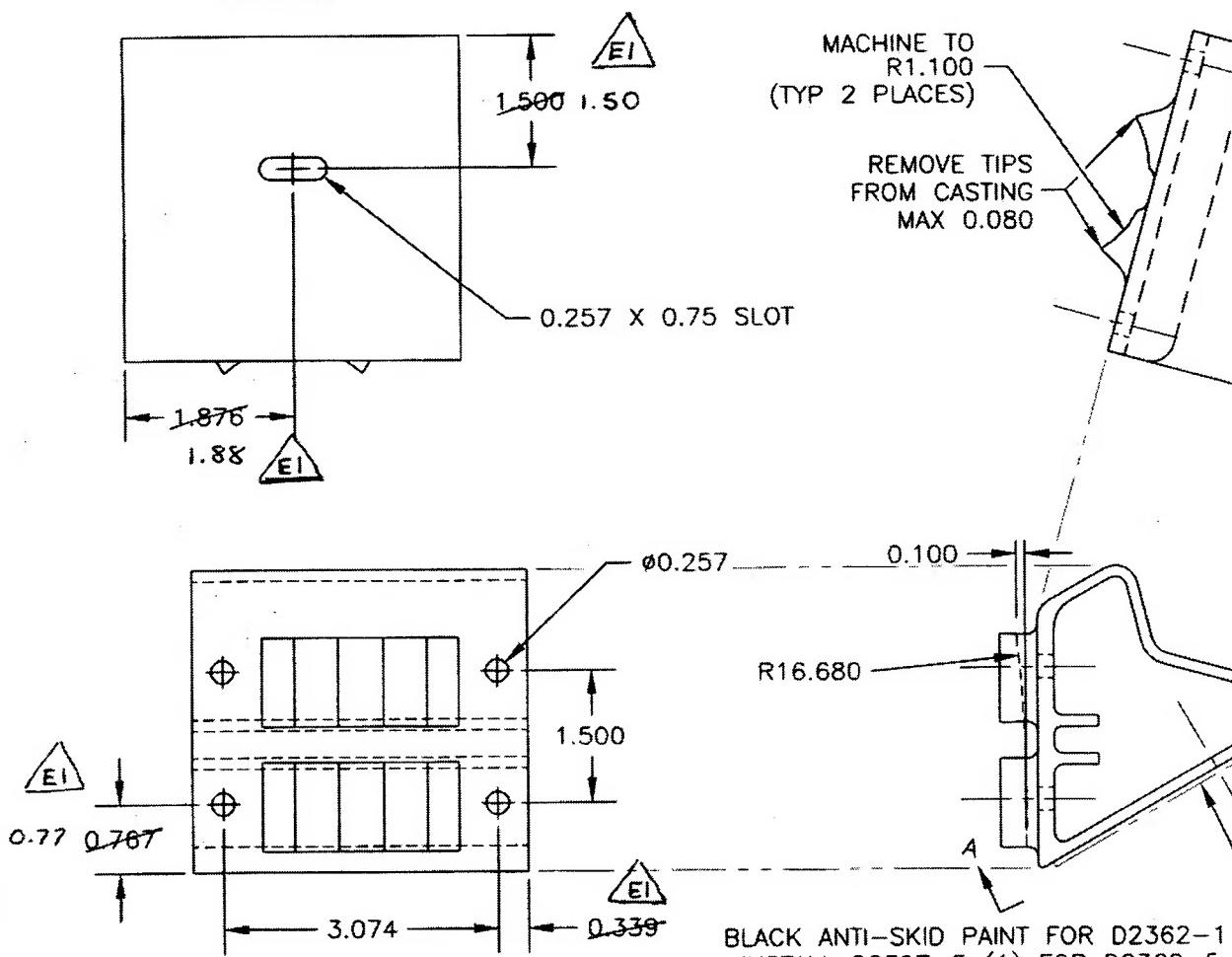
MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



VIEW A-A



D2362-1 & D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART



DESIGN BN	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RE</i>	APPROVED <i>JP</i>	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 2 OF 3 SCALE 1:2

RELEASED
12/14/98
UNDER REVIEW
D2362-5 CP
DESIGNER, BUT CHECKED
BY BENTON MANUFACTURE
OK for D2362-5

D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

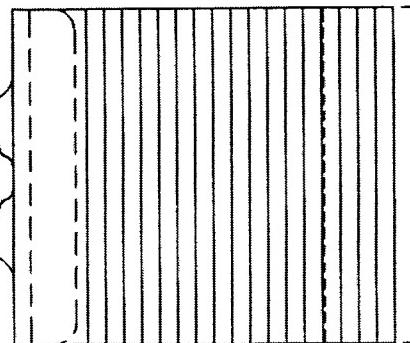
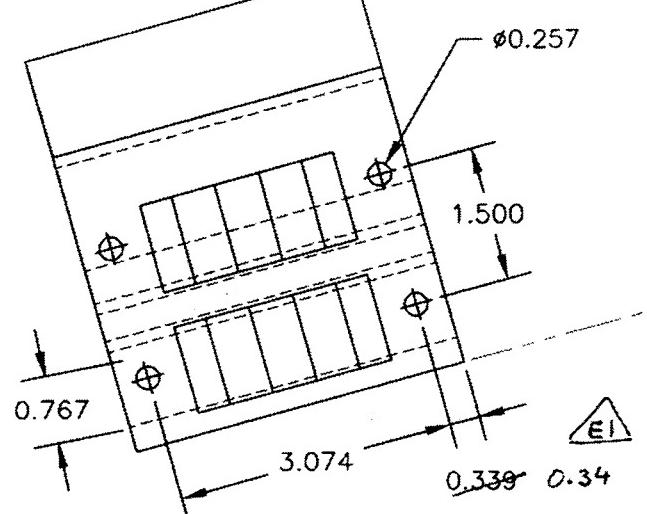
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

REMOVE TIPS
FROM CASTING
MAX 0.080

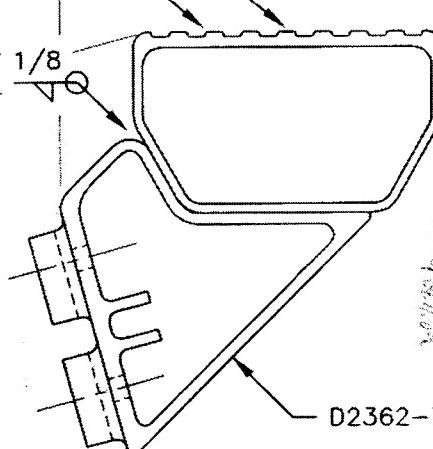
BLACK ANTI-SKID PAINT

D2244-3.75

WELD PER DART 1/8
QSI 004



3.750 (REF)



UNDER REVIEW

RELEASED

516315 CP
DESIGN OK, BUT CHECK NO. 111
3/3 BEFORE MANUFACTURE

OK FOR USE

DESIGN BY	DRAWN BY	DART AEROSPACE LTD
BW		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
RE	M	D2362
DATE		SHEET 3 OF 3
98.12.04		SCALE
		1:2

DART

DA COPY 03/00

Linda Lacelle

From: David Shepherd [davids@dart Aero.com]
Sent: Thursday, December 01, 2005 8:11 PM
To: Linda Lacelle
Subject: Re: D2362

Hi Linda,

Looking at drawing D2362 Rev. E1, I think you can take a D2362-5 and convert it into a D2362-3.

You would have to add the 0.257 x 0.75 slot shown on page 1 and convert the existing 0.257 x 0.75 slot shown on page 2 into the 1.00 x 1.20 cutout shown on page 1. Then you would have to machine to remove the R16.68 shown on page 2.

Add the rubber and voila, D2362-3.

Good luck with that. Sorry for not getting back to you sooner.

David

----- Original Message -----

From: "Linda Lacelle" <llacelle@dart Aero.com>
To: "*David Shepherd (E-mail)" <davids@dart Aero.com>
Sent: Thursday, December 01, 2005 7:24 AM
Subject: D2362

>
> David,
> Is there much of a difference from D2362-5 AND D2362-3 ? Can we take a
> D2362-5 and make it into a D2362-3 ?
> LL
>
>

DART AEROSPACE LTD	Work Order:	25073
Description: Shear support bracket	Part Number:	2362-3
Inspection Dwg: 2362 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:		Audited by:		Prototype Approval:	
Date:	05.12.05	Date:	05.12.05		Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

